

Date: Thursday, 10/08/2006 3:21:09 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GUIDE
Job Number	: 28149	Part Number	: D31373
Estimate Number	: 11073	Drawing Number	: D3137 REV D
P.O. Number	: N/A	Project Number	: N/A
This Issue	: 10/08/2006	Drawing Revision	: D
Prsht Rev.	: NC	Material	: N/A
First Issue	: N/A	Due Date	: 17/08/2006
Previous Run	: 26888	Qty:	40
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:A 02.05.29 New Issue NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	MDELRINB075X1250	Delrin Bar	
		Comment: Qty.: 0.0831 f(s)/Unit Total : 3.3222 f(s) Matl:Black Delrin bar 1.250" x .750" (ref DART spec. M-DELRIN-B) Batch: M100724	J.F. 06/08/12 40
2.0	BAND SAW	BAND SAW	
		Comment: BAND SAW Cut Blanks. Blank size: 1.250" x .750" x .950" long	J.F. 06/08/12 40
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 1-Machine as per Folio FA242 & Dwg D3137	
	2-Deburr		J.F. 06/08/12 40
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	J.F. 06/08/12 40
5.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	S.A. 06.08.13 50

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/08/17
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST410

AB 06/08/16 (40)

7.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(40) AB 06/08/17

Job Completion



AB 06.08.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

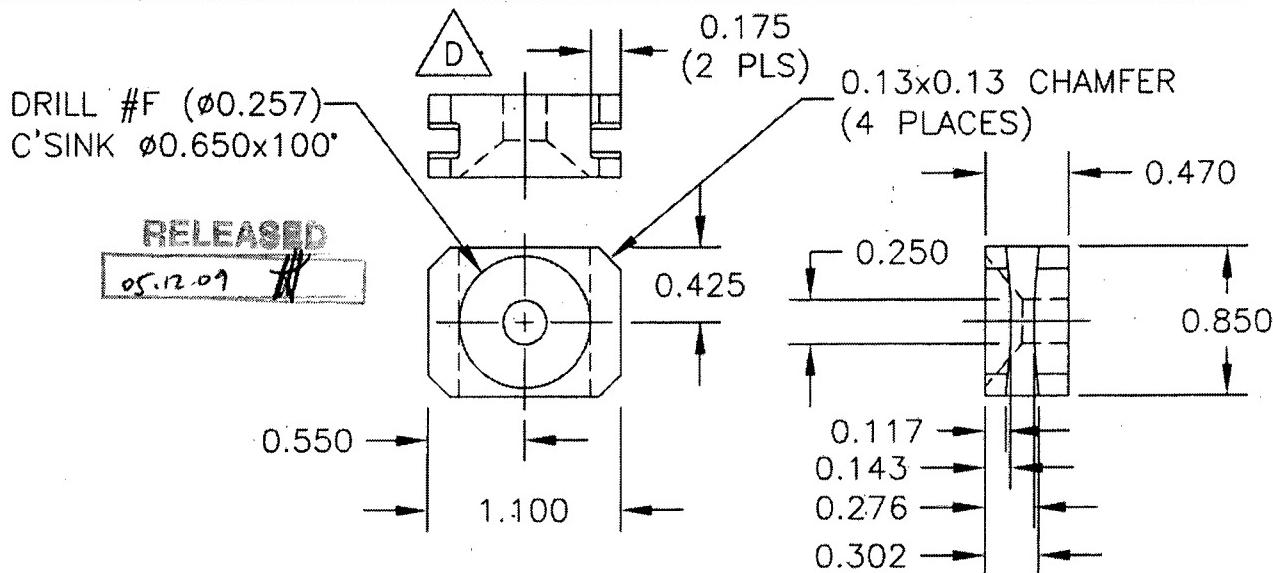
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



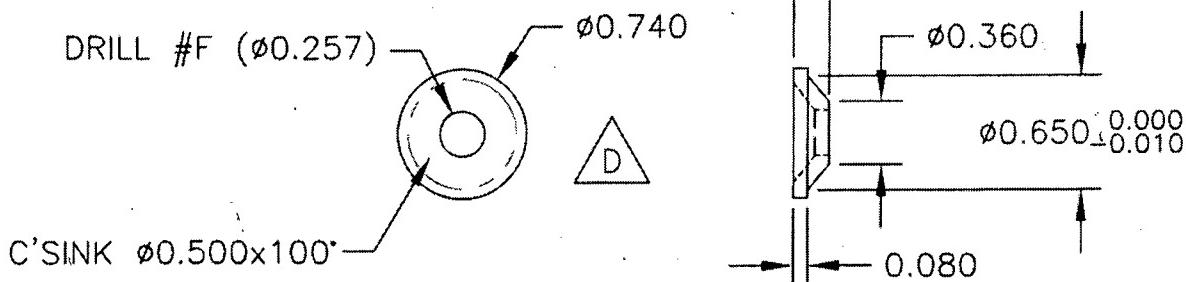
DESIGN DS	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D3137	REV. E SHEET 3 OF 5
DATE 05.11.23	TITLE BRACKET ASSEMBLY	SCALE 1:1	



D3137-3 GUIDE

- 1) REPLACES PREMIER P/N B30-23000-207
- 2) MATERIAL: DELRIN BAR (REF DART SPEC. M-DELRIN-B)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL EDGES 0.005 TO 0.015

REFERENCE ONLY



D3137-5 WASHER

- 1) REPLACES PREMIER P/N B30-23000-209
- 2) MATERIAL: 6061-T6 (QQ-A-225/8 OR QQ-A-200/8) BAR (REF DART SPEC. M6061T6R)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL EDGES 0.005 TO 0.015

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DART AEROSPACE LTD	Work Order:	
Description: Guide	Part Number:	D3137-3
Inspection Dwg: D3137	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	J.F.	Audited by:	SD	Prototype Approval:	N/A
Date:	06/08/12	Date:	06.08.12	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.11.27	New Issue	KJ/RF	
B	04.11.12	0.175 was 0.145 & Ø0.65 x 100° was Ø0.75 x 100°	KJ/JLM	
C	06.03.15	Dwg Rev update	KJ/JLM	